

Date: Wednesday, 9/12/2007 12:13:32 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING
Job Number : 34604	
Estimate Number : 10089	
P.O. Number : <i>N/A</i>	Part Number : D312123
This Issue : 9/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3121 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 34524	Material : <i>N/A</i>
Written By : _____	Due Date : 9/30/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.09.12	
Comment : Est. A: 04.02.19 New Issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *4578*

Bearing as per Dwg D3121

Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-ZZ

Material release note is required

U 07-09-13 40

2.0	6900ZZ	Bearing
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)
 Bearing

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

7/9/17 SD 40x

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3121 and attached certification Dwg Rev *P*
Er 07/09/18
counters
(40)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5766*
CP 07/09/19 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 34604

Part Number: D312123

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: D 07/08/07

Job Completion



Handwritten: U 07/09/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

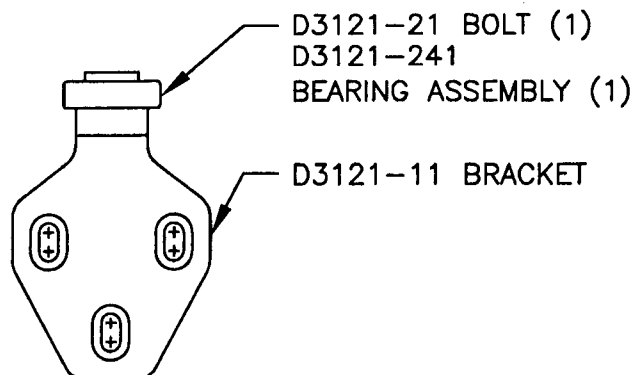
NOTE: Date & initial all entries

DART

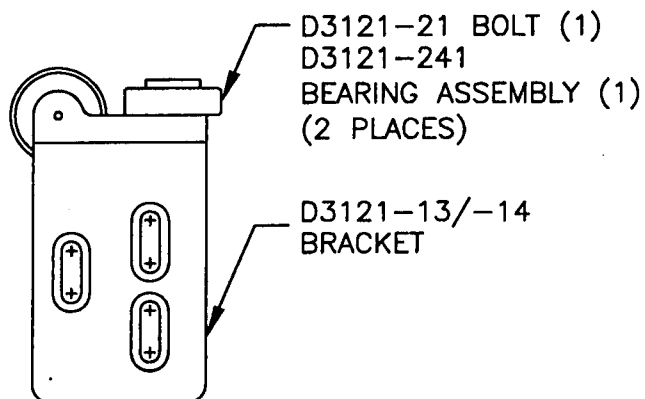
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CHECKED	APPROVED	DRAWING NO.	REV. D
		D3121	SHEET 1 OF 10
DATE		TITLE	SCALE
06.05.17		BRACKET ASSEMBLY	1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	

RELEASED

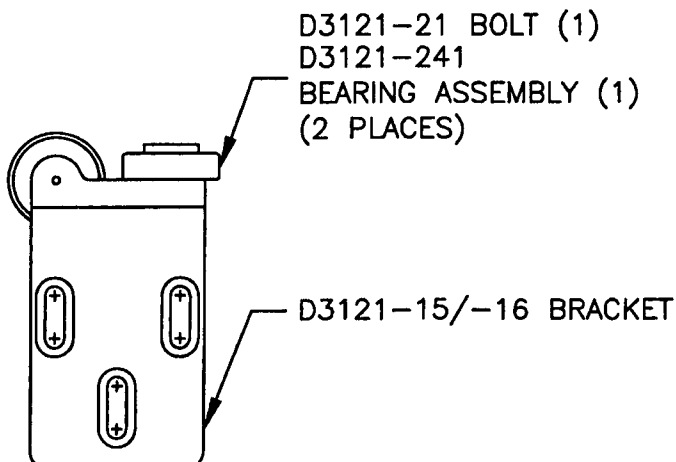
06.06.02



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

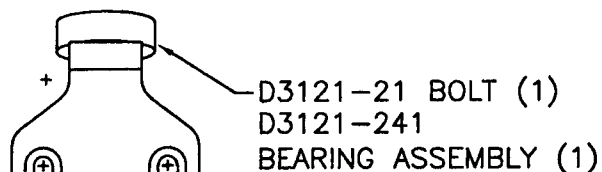
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WORK ORDER
NO. 34604

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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

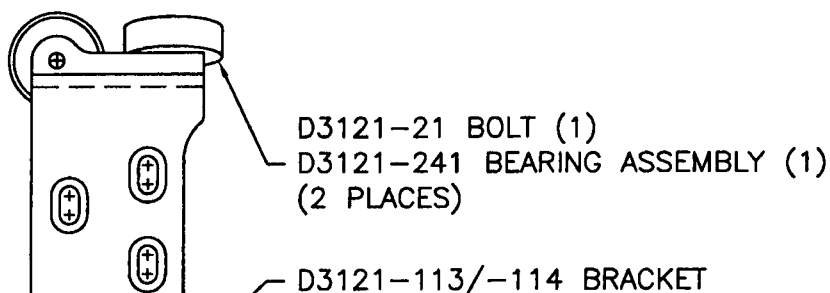


D3121-111 BRACKET

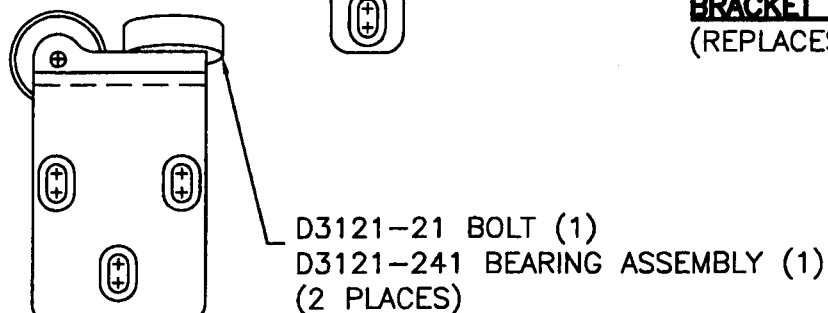
D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

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06.06.02 J.H.



D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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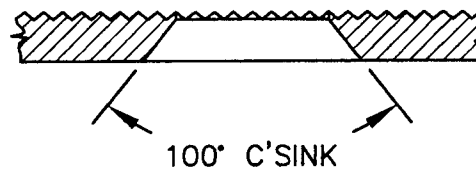
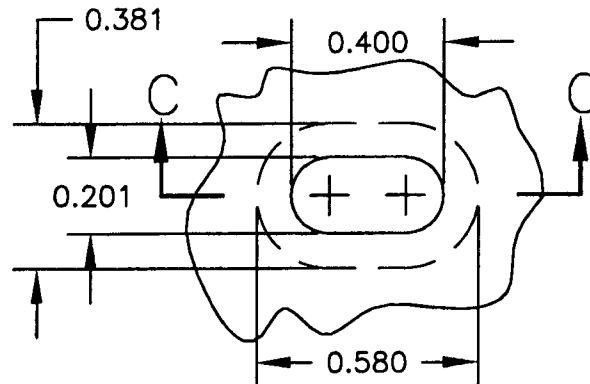
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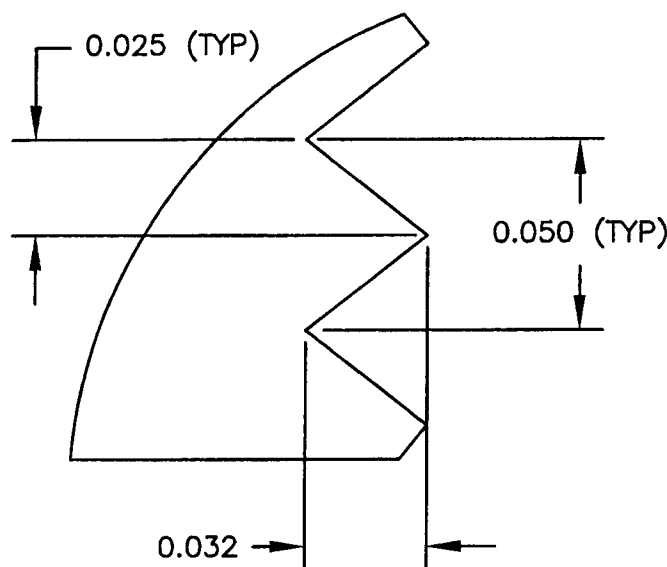
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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**DETAIL A:
SLOT DETAIL**
SCALE 2:1
VIEW ROTATED



**SECTION
C-C**

**DETAIL B:
RIDGE DETAIL**
PARTIAL SECTION
SCALE 1:20



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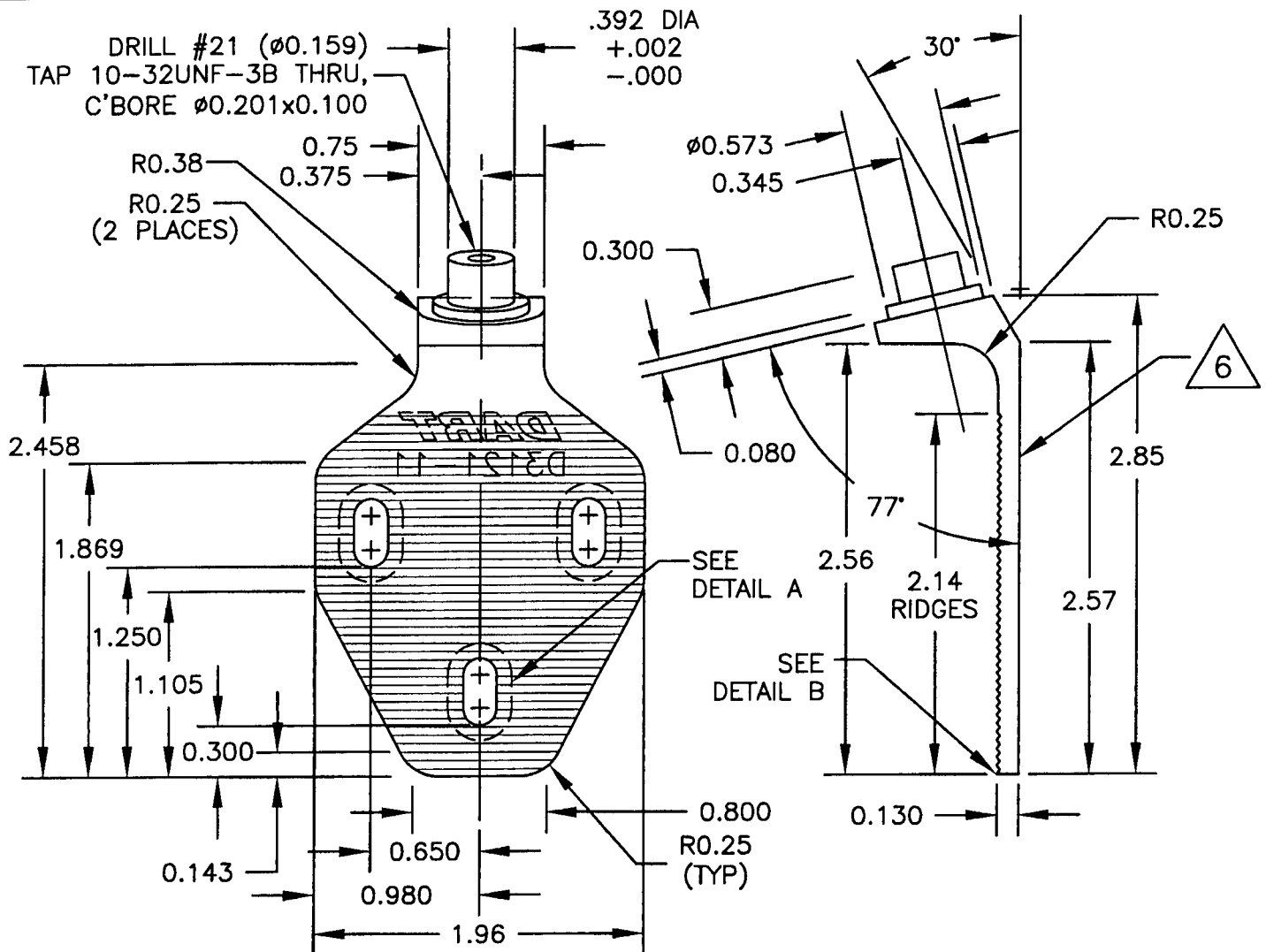
do. de. or #

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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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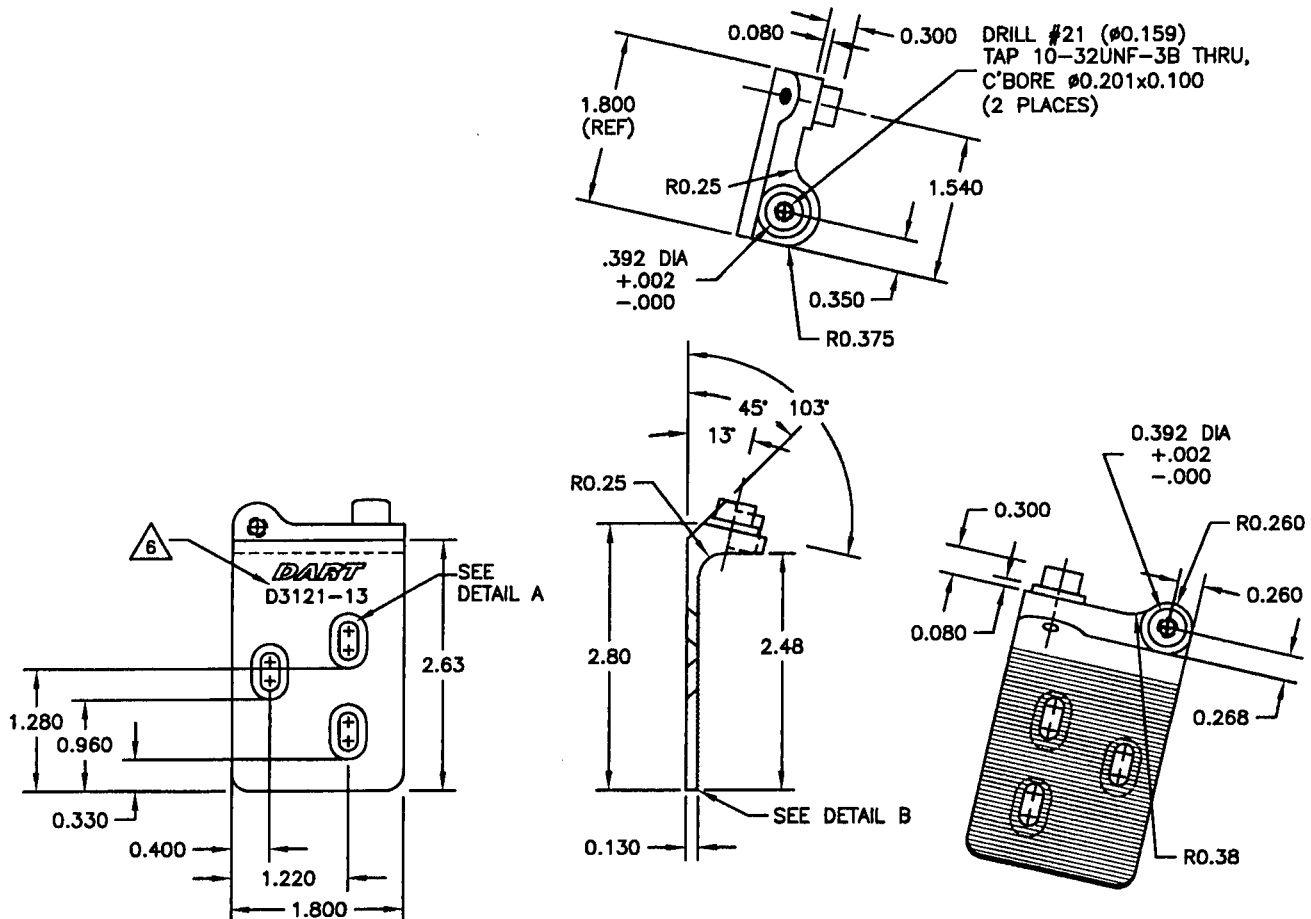
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DATE 06.05.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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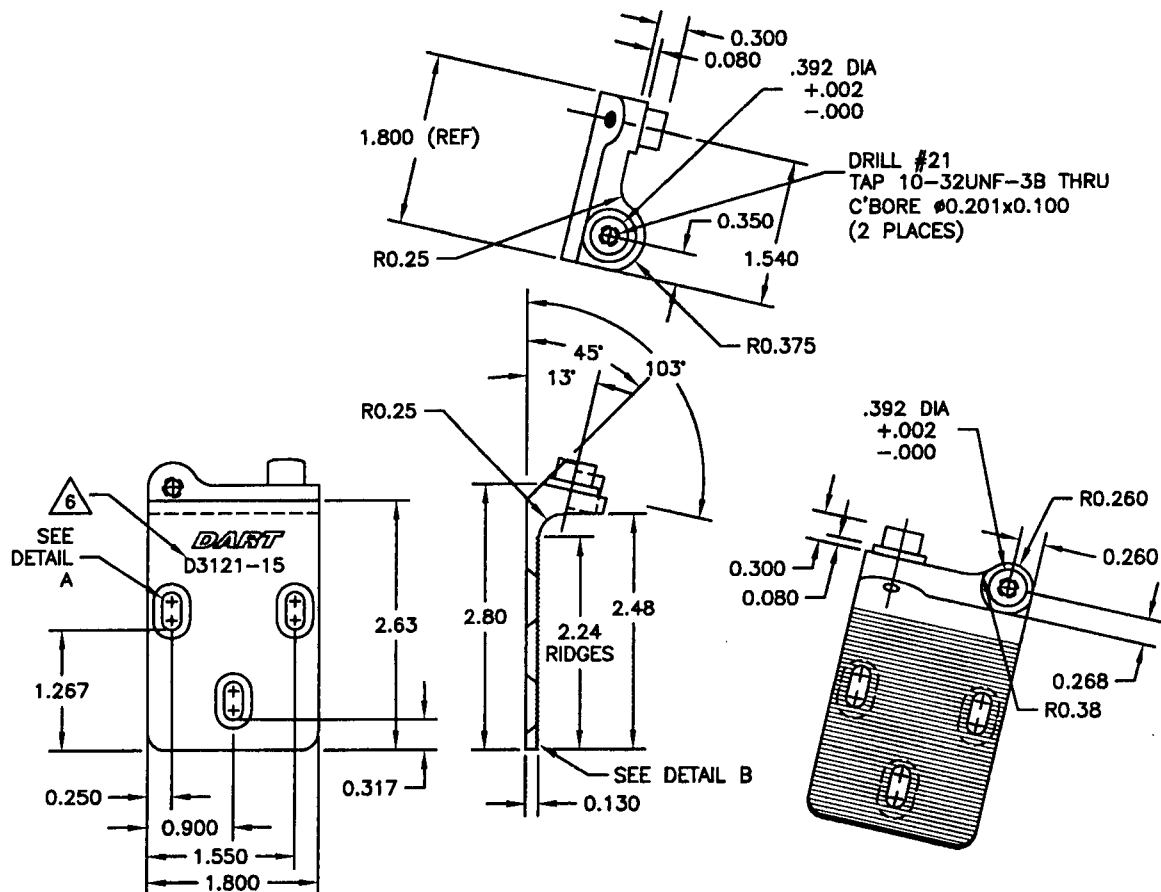
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2



D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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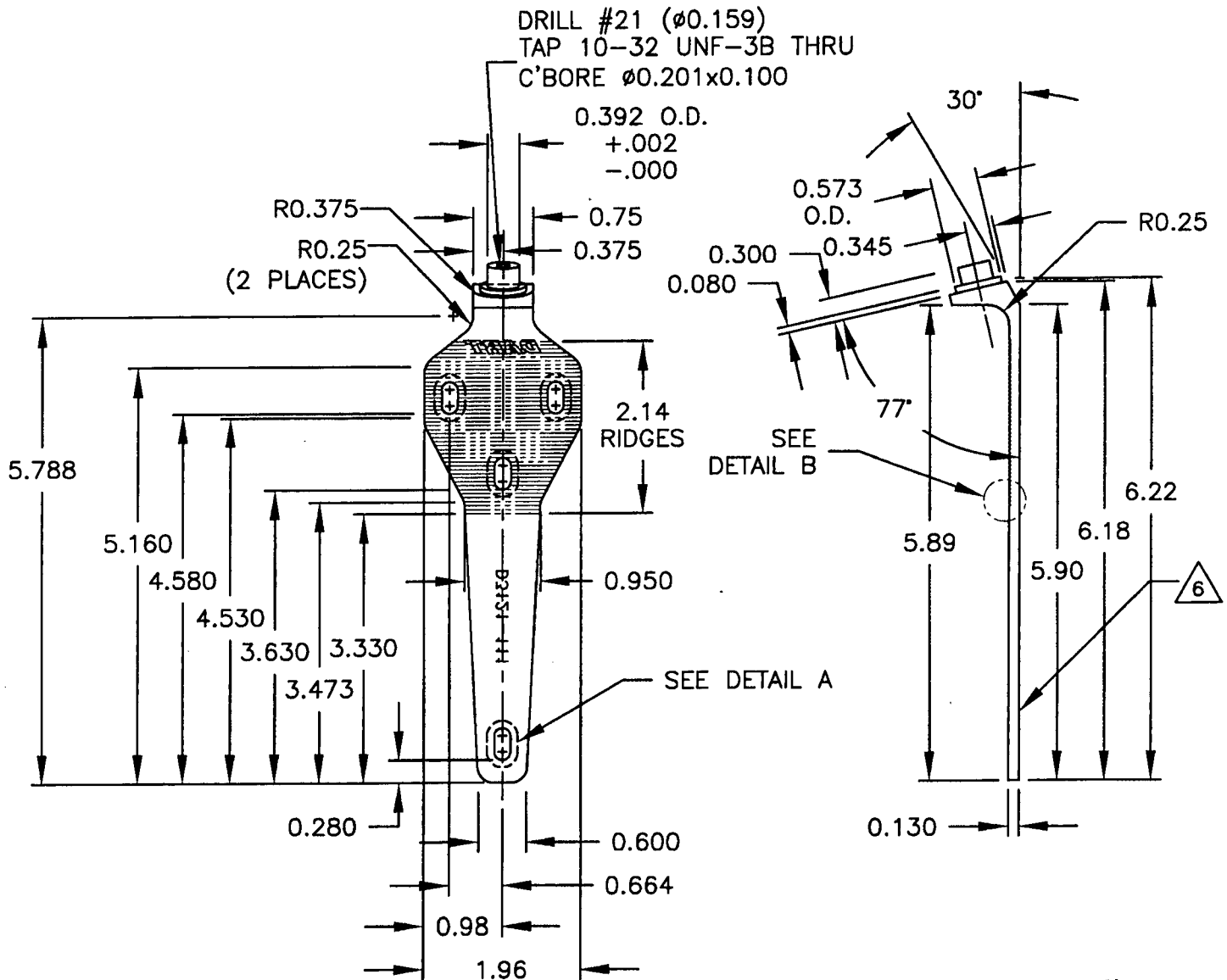
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DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:2

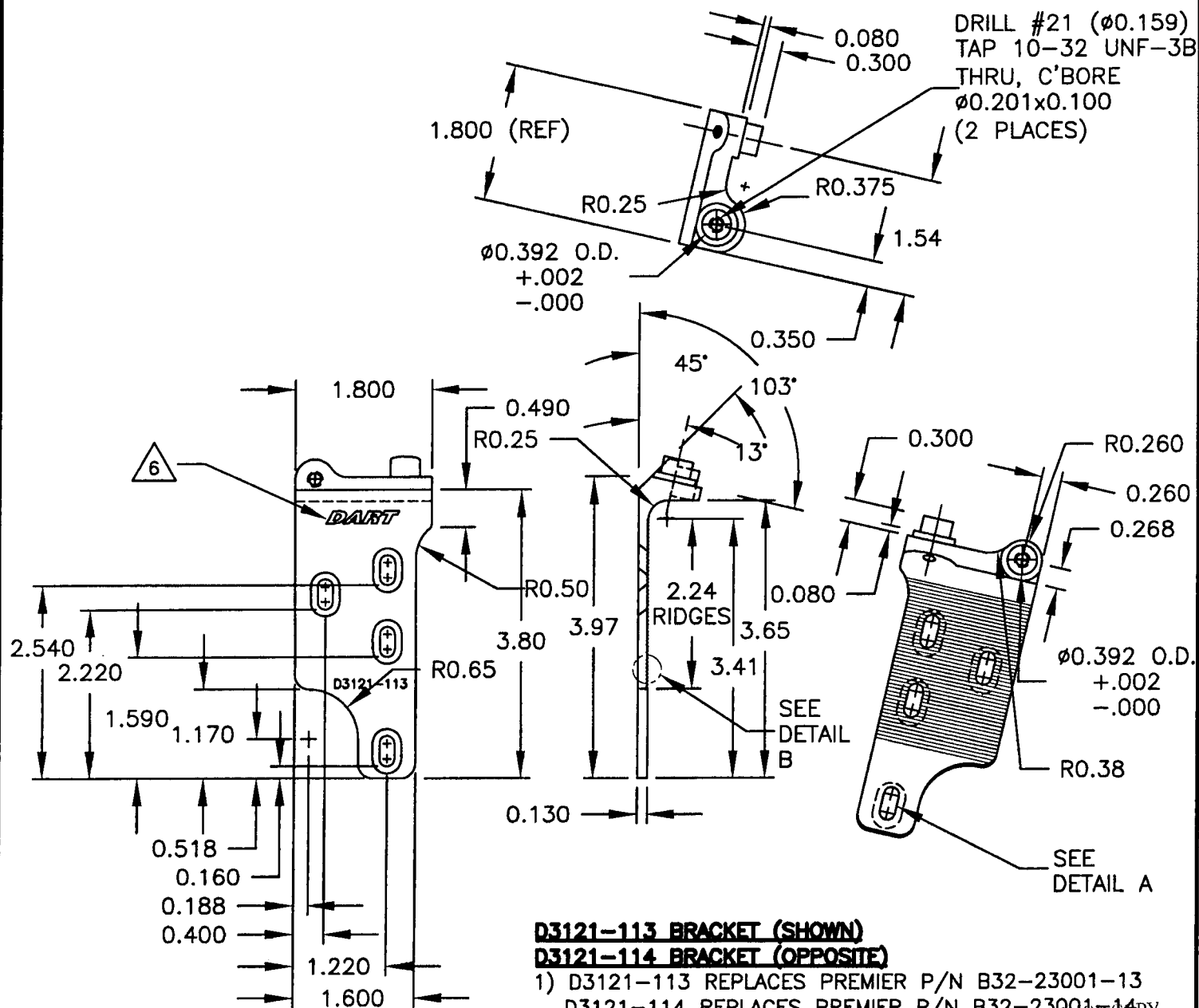
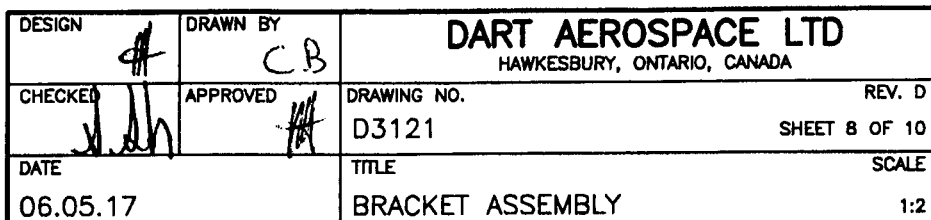
**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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NO. 34604
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06.06.02

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06.06.02

D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015 IN.
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005
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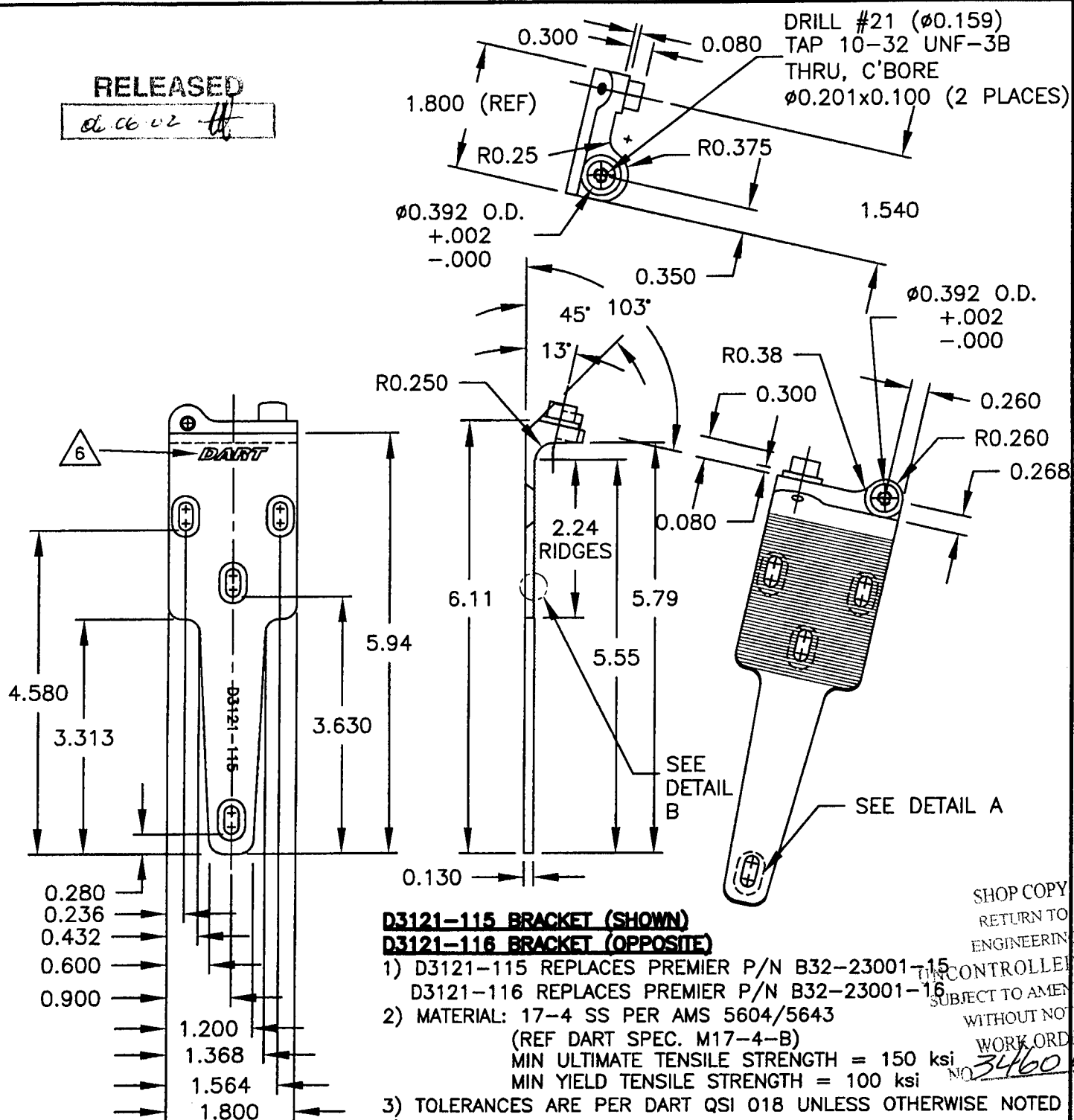
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CHECKED J.H.	APPROVED J.H.	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED

04.06.02 J.H.

**D3121-115 BRACKET (SHOWN)****D3121-116 BRACKET (OPPOSITE)**

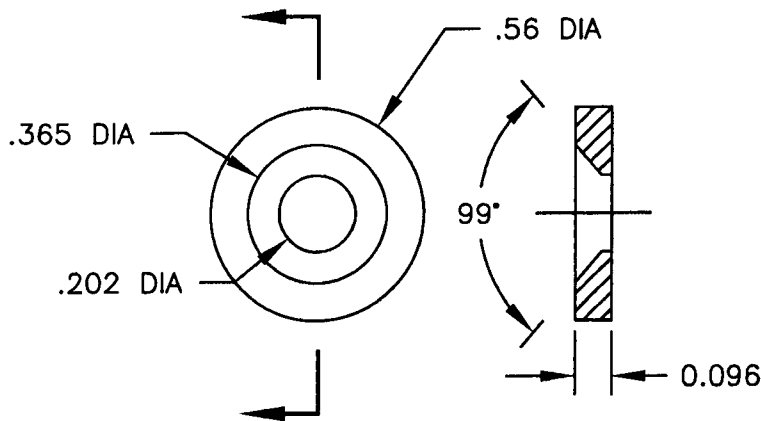
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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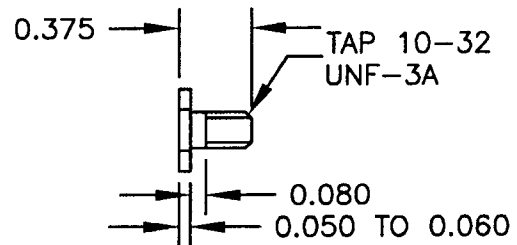
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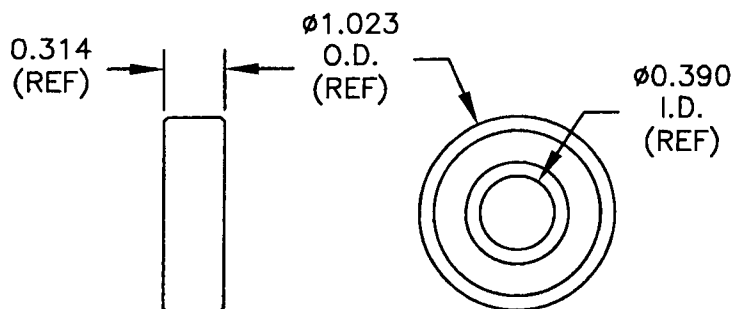
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. D SHEET 10 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

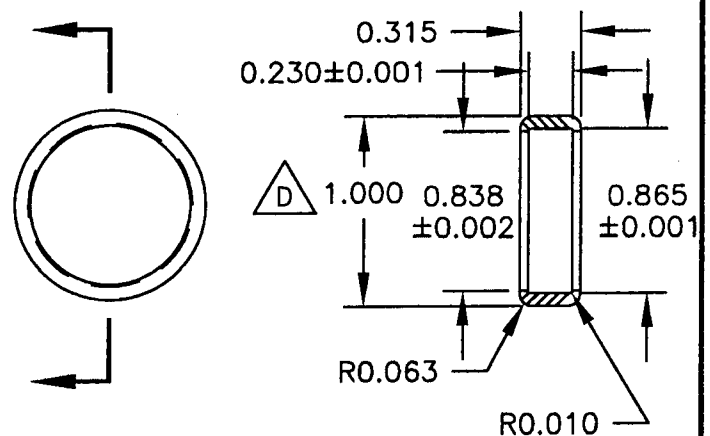
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-21 BOLT (SCALE 1:1)**

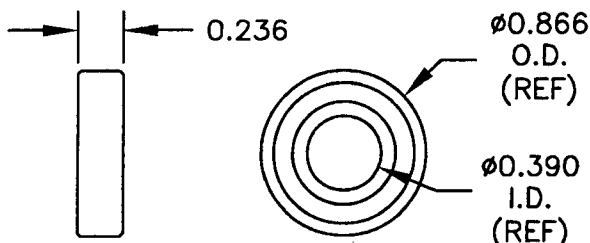
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

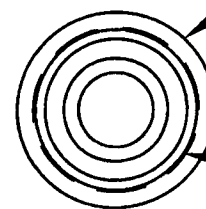
**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

RELEASED
06-06-02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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NO. 34604
D3121-23 BEARING

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DART

Purchase Order

Date Sep 13, 2007	Page 1
Purchase Order Number PO00004573	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED


Vendor Address:

General Bearing Service
3861 Main Street
Hawkesbury, ON K6A 1A5
Phone: (613) 632-9914
Fax: (613) 632-2751

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-GEN001	Sep 13, 2007	N30		Sep 18, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
40.0000 7/9/17 SO	6900ZZ	Bearing Comments: PER DRWG D3121 REV.D SKF P/N 61900-ZZ OR KML P/N 6900-ZZ	18/09/2007	No	4.970000	Each	198.80
CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY							
Comments:		Tax Summary:		Less:			
		GST	11.93	included tax		0.00	
		GSTME	0.00	Subtotal		198.80	
		GSTND	0.00	Total tax		11.93	
		Entered By: LIACELLE		Total purchase order in			
		Approved By: 		CAD Dollars		210.73	

GENERAL BEARING SERVICE • INC.

cie

GENERAL BEARING SERVICE

www.gbs.ca

Inc.

306 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

ORDER DATE: SEP 14, 2007

GST # R101979094

SOLD TO: DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY, ON.

K6A-1K7

SALE MADE BY: DR
SHIP VIA: DICOM H29996595

CUSTOMER ORDER #: PD00004578

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6900-ZZ	BALL BEARING	40	40	4.97	198.80
				G.S.T.	11.93

7/9/11
SP

PACKING SLIP NO: 463463-0

RECEIVED BY:

1282605

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

THIS FORM MUST BE COMPUTER PRINTED TO BE VALID. E & O.E.
DOIT ÊTRE IMPRIMÉ PAR ORDINATEUR POUR ÊTRE VALIDE. E & O.E.